

Work Order ID 81722

81722

Page 1

March-19-12 8:43:48 AM

Item ID: D3340-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Skidtube Protector

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3340

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

1010 , 040"

4 0 Jan 12-6-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jan 12-6-25

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(4) Jan 12 06 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81722

March-19-12 8:43:48 AM

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Page 2

Item ID: D3340-3

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Setup Start

NS1

Revision ID:

Item Name: Fwd Skidtube Protector

Stop

NS2

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form on brake as per Dwg D3340								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:50 OVEN TEMPERATURE:								
	FINISH TIME: 7:20								

m121279

3200 F

7:20

4X

m12
12/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Item ID: D3340-3

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Skidtube Protector

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: SI499	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

H φ 127-4

4x SP 12-7-5

CK 12/7/6

MF 12-07-

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NOTE: Date & initial all entries

Picklist Print

March-19-12 8:43:52 AM

Page 1

Work Order ID: 81722

81722

Parent Item: D3340-3

D3340-3

Parent Item Name: Fwd Skidtube Protector

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B now water jet 07-11-14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S19GA

Purchased

No

100

sf

0.0000

0.968

4.075789

M1010S19GA

**

1010/1025 SHEET .040

Jun 12-6-25

121780

121780

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81722
Description: Fwd Skidtube Protector		Part Number:	D3340-3
Inspection Dwg: D3340	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250 x 0.300	+/-0.010	0.256" x 0.300"	✓		✓	mm01
0.250 x 0.530	+/-0.010	0.254" x 0.534"	✓		✓	"
0.50	+/-0.030	0.497"	✓		✓	"
0.250	+/-0.010	0.251"	✓		✓	"
1.625	+/-0.010	1.626"	✓		✓	"
1.815	+/-0.010	1.817"	✓		✓	"
2.315	+/-0.010	2.315"	✓		✓	"
2.315	+/-0.010	2.310"	✓		✓	"
20.313	+/-0.010	20.313"	✓		MT	H301
23.813	+/-0.010	23.813"			MT	"
38.200	+/-0.010	38.200"			MT	"
41.700	+/-0.010	41.700"			MT	"
44.015	+/-0.010	44.015"			MT	"
47.515	+/-0.010	47.515"			MT	"
49.505	+/-0.010	49.505"			MT	"

Measured by:	JM	Audited by:	MT	Prototype Approval:	N/A
Date:	12-6-25	Date:	12-6-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	JD

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

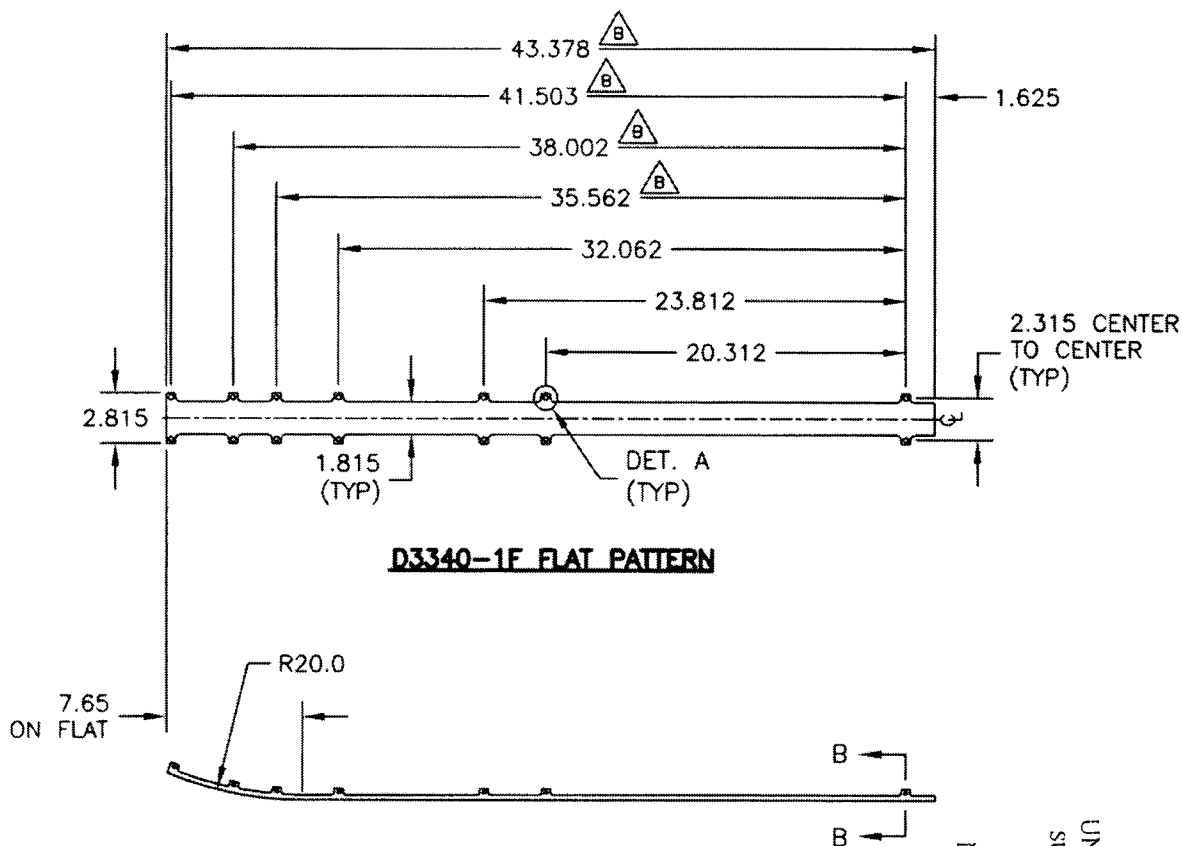
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 1 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

RELEASED
05.11.28



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81722 MJS
12/03/19

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

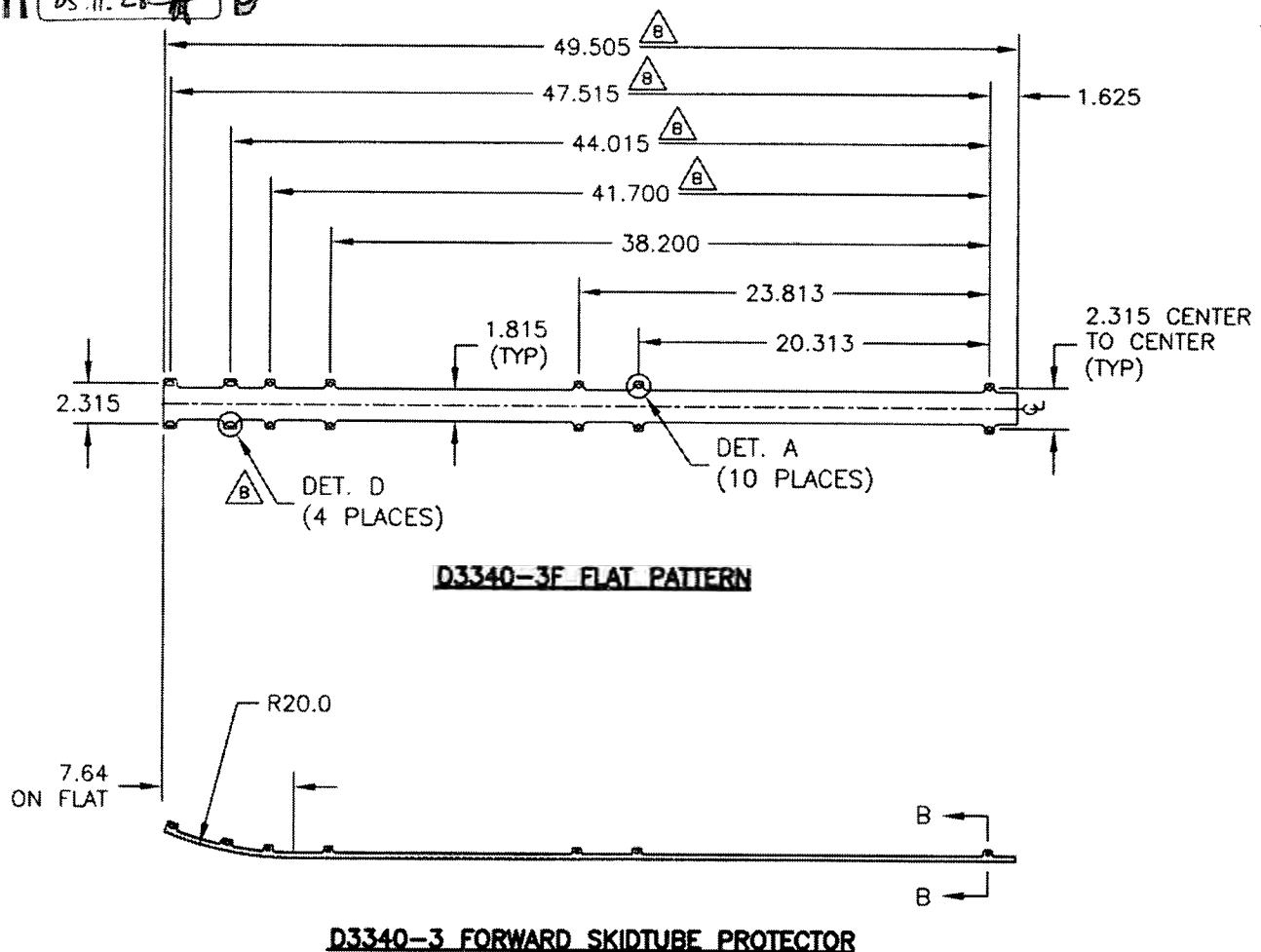
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.22



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

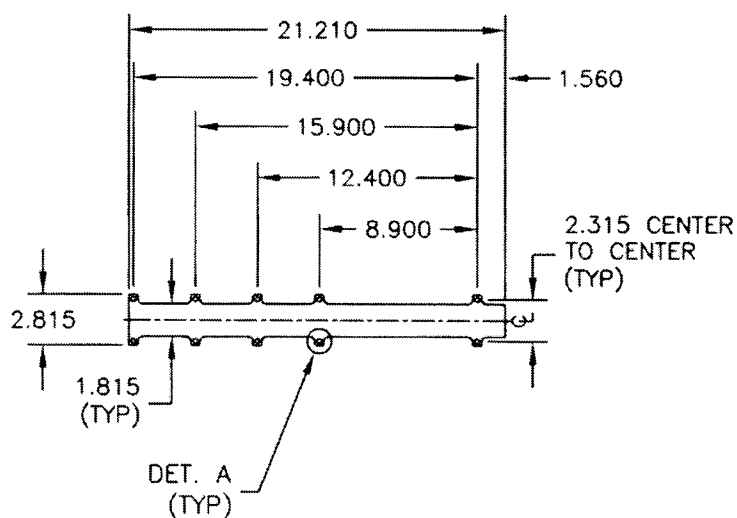
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CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 3 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.28



D3340-5F FLAT PATTERN



D3340-5 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

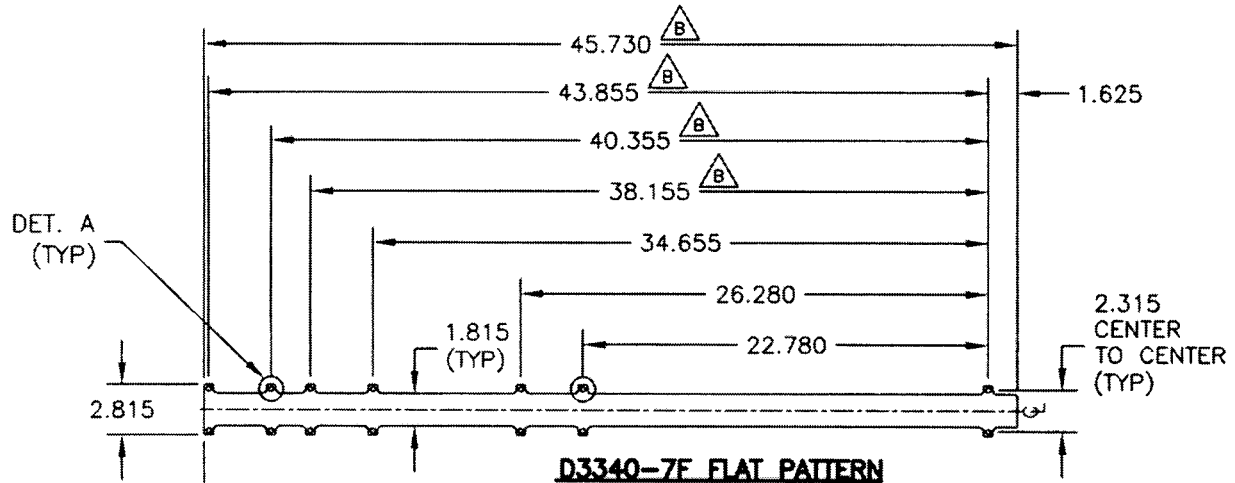
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

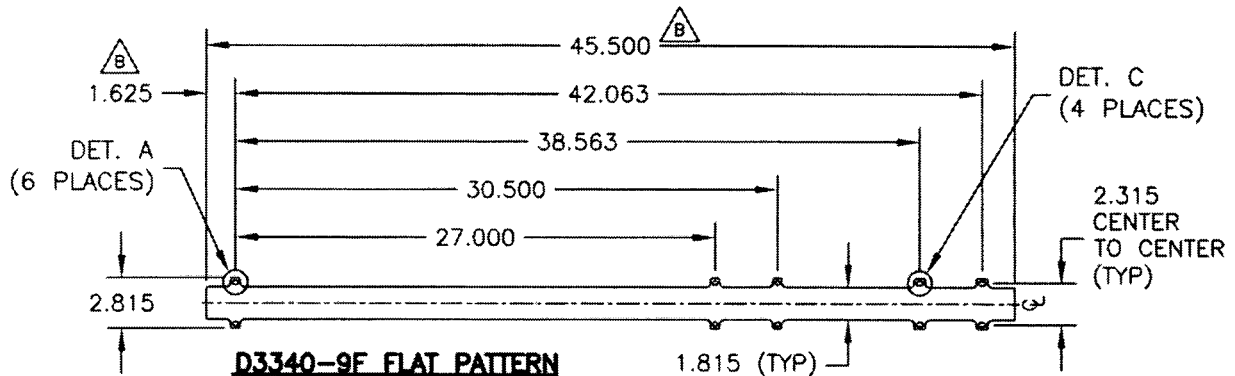
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CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-7 FORWARD SKIDTUBE PROTECTOR



D3340-9 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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05.11.28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

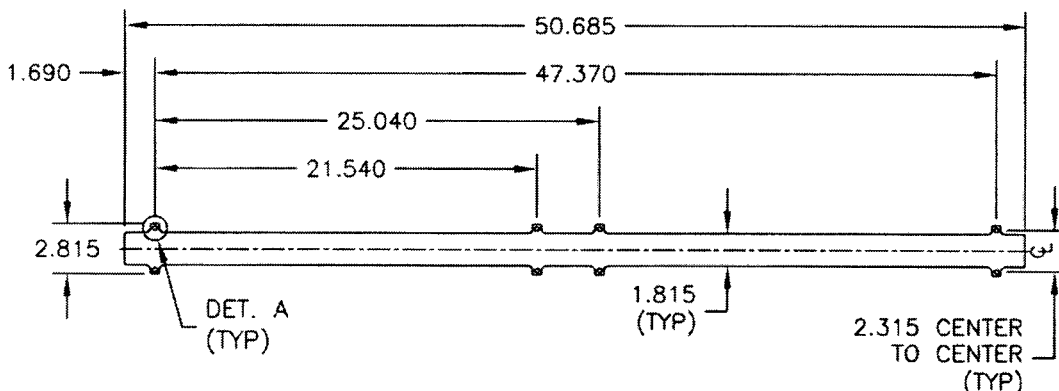
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 5 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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D3340-11F FLAT PATTERN



D3340-11 CENTER SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

22x100

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

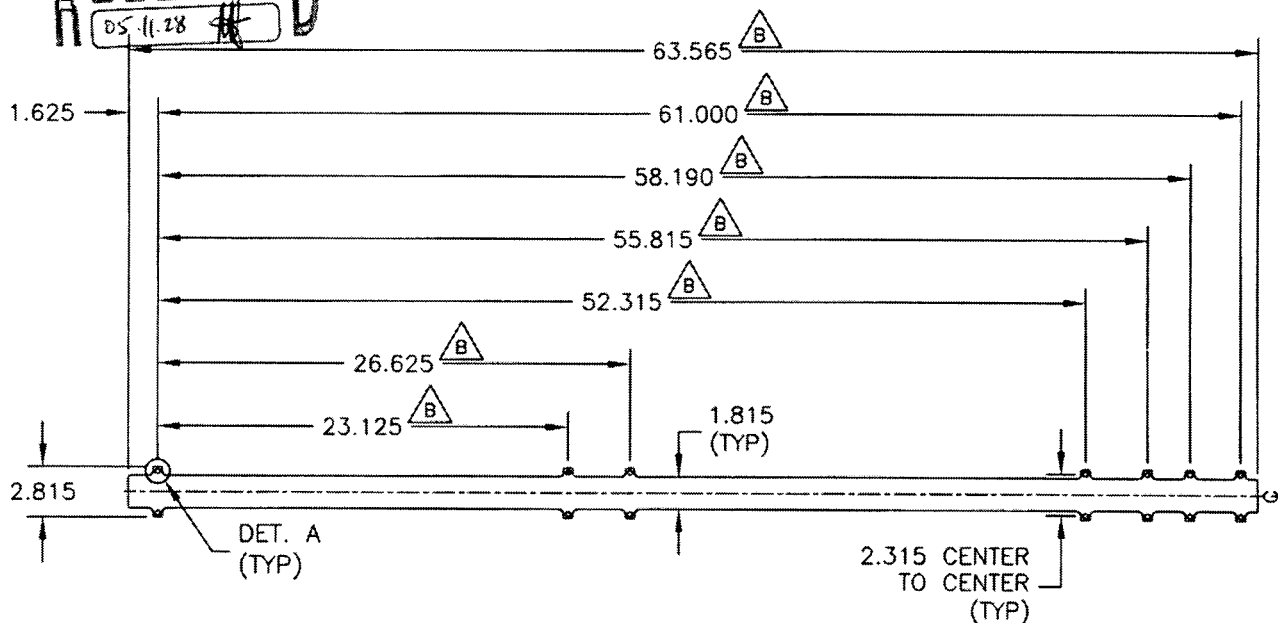
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CHECKED H	APPROVED H	DRAWING NO. D3340	REV. B SHEET 6 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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05.11.28 H



D3340-13F FLAT PATTERN



D3340-13 AFT SKIDTUBE PROTECTOR

NOTES:

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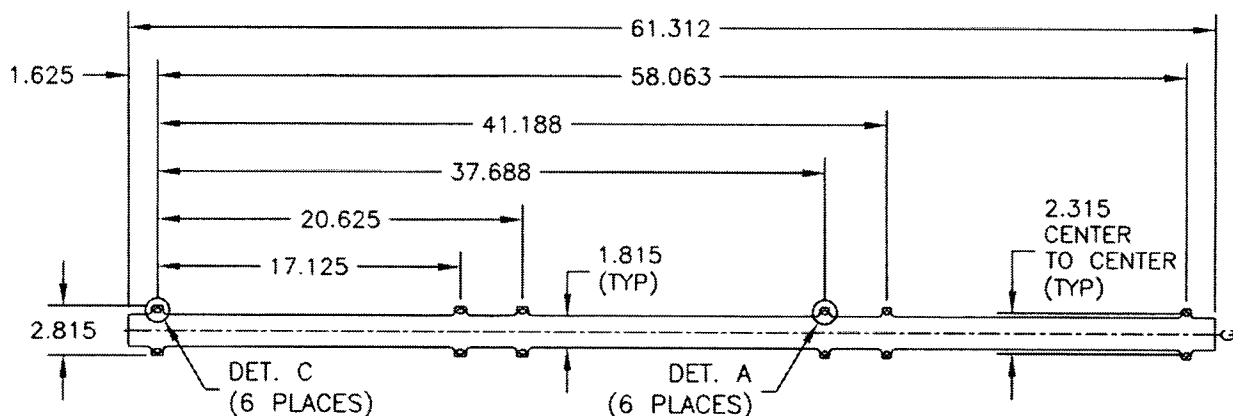
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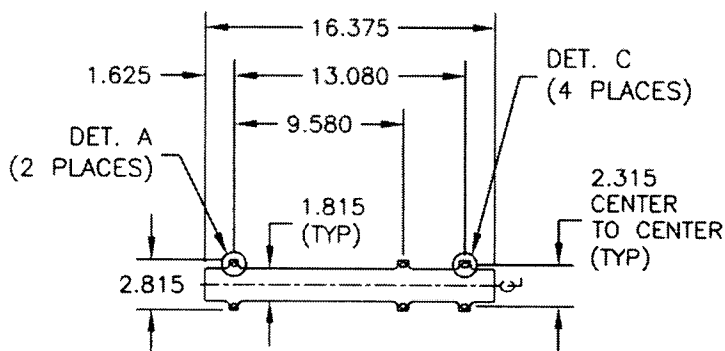
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 7 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-15F FLAT PATTERN

RELEASED
05.11.22

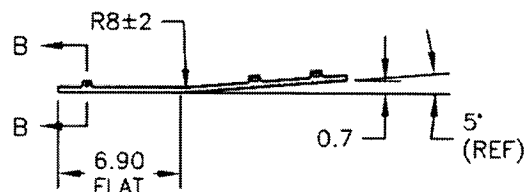
D3340-15 CENTER SKIDTUBE PROTECTOR



D3340-17F FLAT PATTERN

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D3340-17 AFT SKIDTUBE PROTECTOR

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

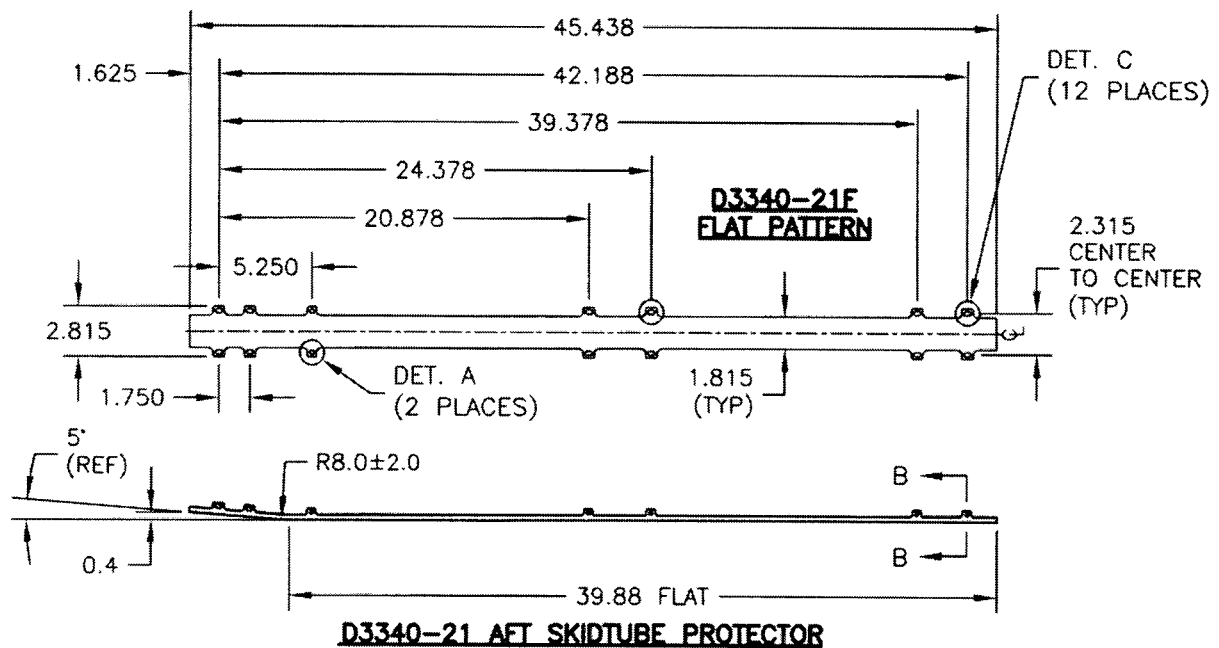
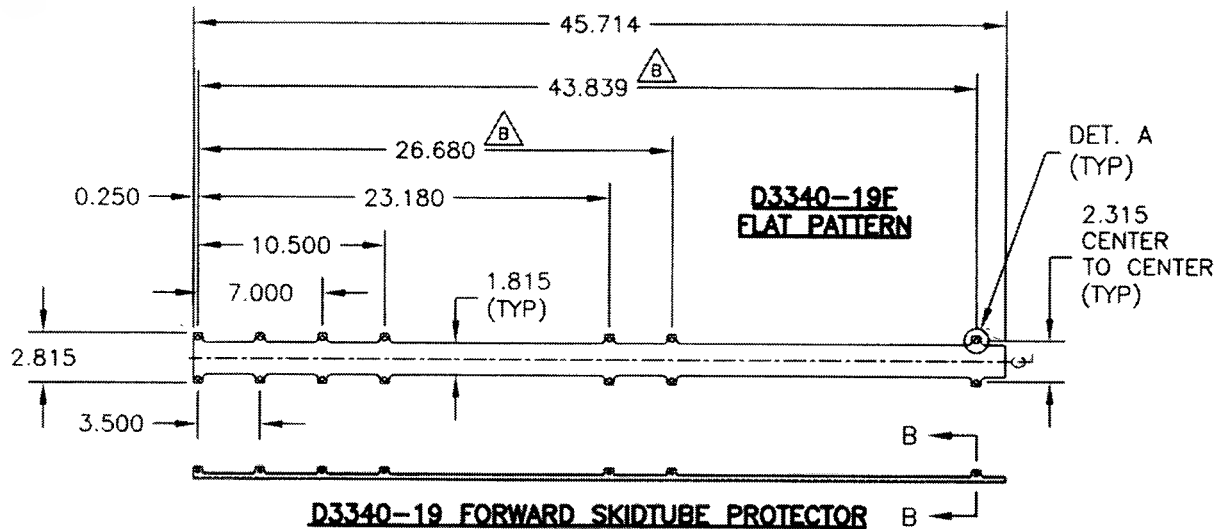
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 8 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

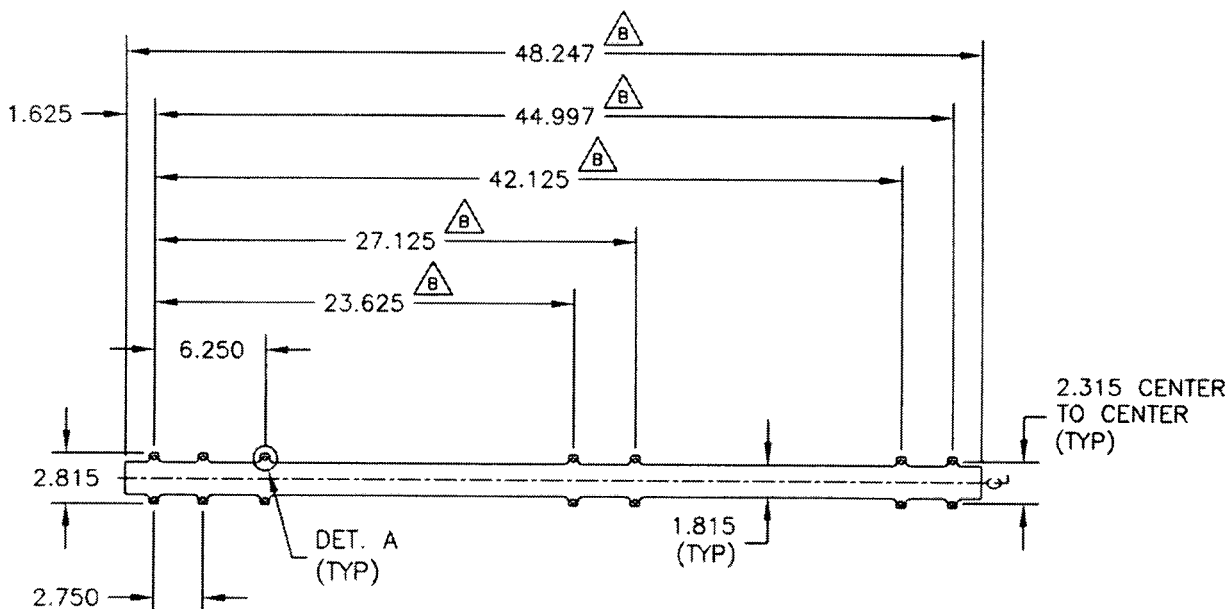
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

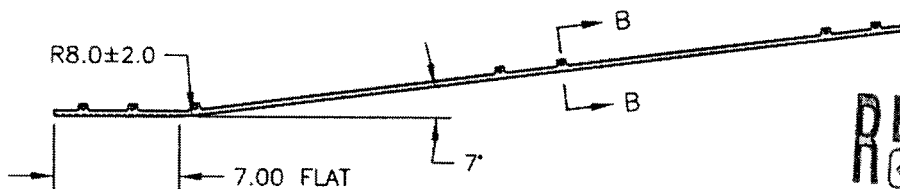
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3340	REV. B SHEET 9 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-23F FLAT PATTERN



D3340-23 AFT FLOAT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

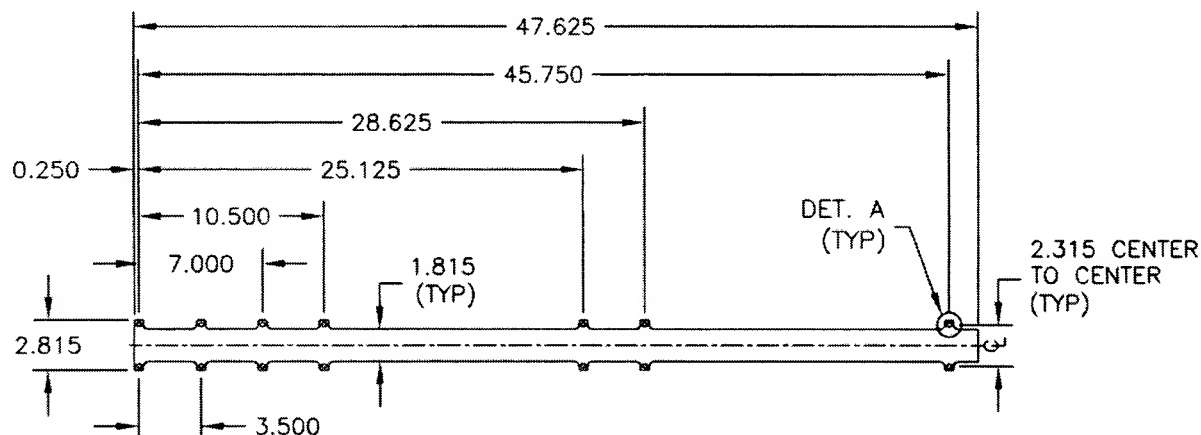
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

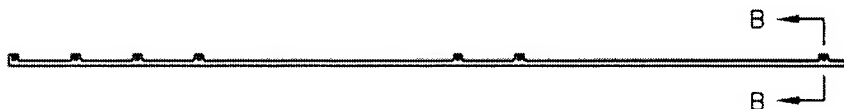


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 10 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-25F FLAT PATTERN

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D3340-25 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

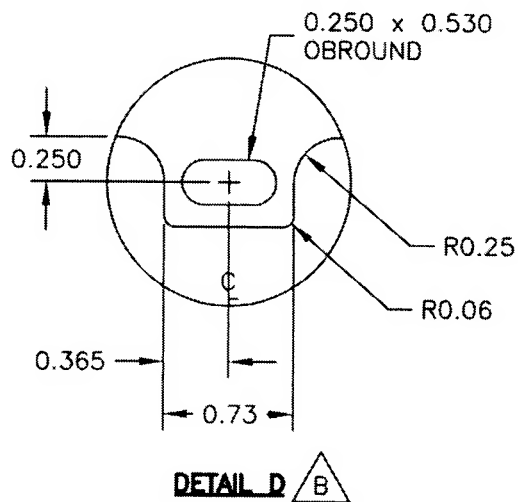
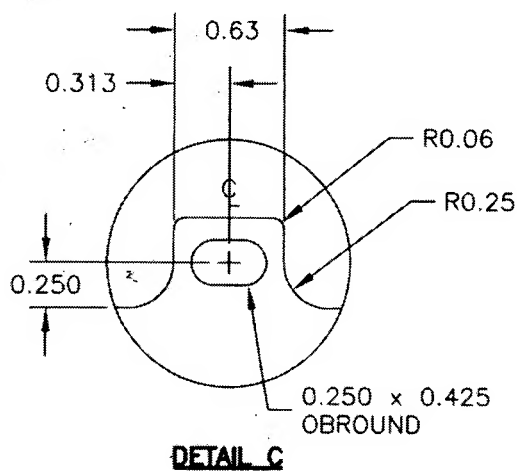
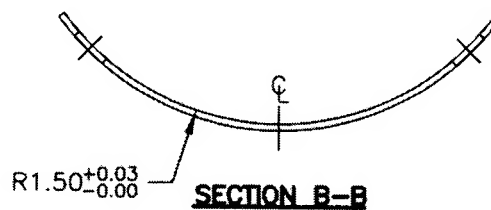
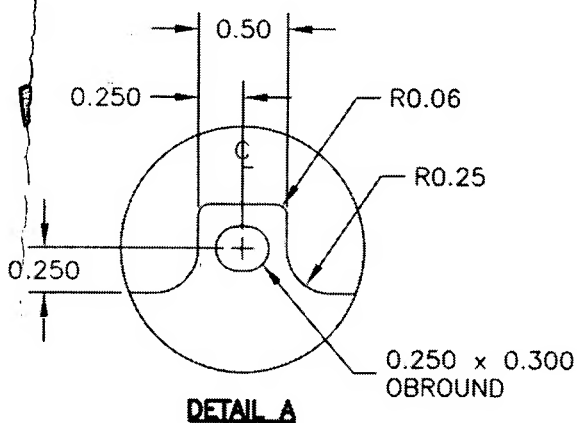
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. 8 SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries